

ENGINEERING CHANGE NOTICE

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|--|--|--|-------------|---------------|-------------|
| Date: 99-03-04 | ECN #: 164 | | | | |
| Project No.: P371 rev B | Created By: KE | Checked By: # | | | |
| Project Name: Bear Paw Review | Approved By: (proj. manager) KE | Approved By: (management if req'd) N/A | | | |
| Description of Change: P350-578 / D205-564 / D206-559 / D500-572 - Eliminated D2771 bolts and nuts from all bear paw installations in response to NCRs about bolts breaking. Released: DSI 9140 rev.A DSI 9141 rev.A DSI 9142 rev.A DEO 9143 rev.A Revised: D206-559 to rev G - All 4 installations reverted back to older revisions of installation dwgs. - All new installations will be change 4. (see attached sheet) | | | | | |
| Notification/Acceptance | Affected <input checked="" type="checkbox"/> | Authorization | | | |
| QA | <input checked="" type="checkbox"/> | NCR 013 / 015 | | | |
| Production | <input checked="" type="checkbox"/> | | | | |
| Planning | <input checked="" type="checkbox"/> | | | | |
| Marketing | <input checked="" type="checkbox"/> | | | | |
| Engineering Actions | Yes | No | Responsible | To happen by: | Complete |
| Update Blue File | <input checked="" type="checkbox"/> | | KE | 99.03.05 | KE 99.03.04 |
| Update Pink File | <input checked="" type="checkbox"/> | | " | " | KE 99.03.04 |
| Update D-Part Master Binder | <input checked="" type="checkbox"/> | | " | " | KE 99.03.04 |
| Update Grey Project Binder | <input checked="" type="checkbox"/> | | " | " | KE 99.03.04 |
| Update DEO Binder | <input checked="" type="checkbox"/> | | " | " | KE 99.03.04 |
| Update Master Document List | <input checked="" type="checkbox"/> | | " | " | N/A |
| Update Drawing Approval Record | <input checked="" type="checkbox"/> | | " | " | N/A |
| Notify TCA of Change | <input checked="" type="checkbox"/> | | " | 99.04.02 | KE 99.04.21 |
| Notify FAA of Change | | <input checked="" type="checkbox"/> | | | |
| Notes: <ul style="list-style-type: none"> - Update IPPs for D206-559 / D205-564 / P350-578 / D500-572 All Kits. (BOMs / pick lists) and paperwork - Remove old hardware from all kits in stock and replace w/new (see attached) - Re-label all kits in stock w/ change number 3 or 4 (see attached) - Update QSI 014 - HAAs programs for all bearpaws to be updated per DEO 9143 rev A (remove top c bore) before next production run. - PURCHASING, do not buy any more D2771-BCFC-025-175 D2771-BCFC-025-190 D2771-LCC-025 | | | | | |

same box as ~~D206~~ 559-013

D350-578-011 and -021

For existing kits in stock

- remove paperwork
- remove all D2771-BCFC-025-175 bolts (QTY 12)
- remove D2771-LCC-025 nuts (QTY 24)
- remove 12 of 24 D2529 washers (ensure QTY 12 remain in kit)
- ensure no D2022-101 spacers are in kit
- add AN4-17A bolts (QTY 12)
- add AN960JD416 washers (QTY 24)
- add MS21042-4 (or MS21042L4) nuts (QTY 12)
- add new paperwork with DSI 9141, drawing D350-578 rev C

Change Numbers (QSI 014)

- "change 3" should be indicated on paws that are in stock and have new hardware added. They can be identified by having a counterbore on the top surface of each clamp hole.
- "change 4" should be indicated for new production of bearpaws, which will not have a counterbore on the top surface of each clamp hole.

For production

- change HAAS programs for bearpaws to remove top counterbore
- update IPPs and BOMs to reflect new hardware

D500-572

box
same as D206-559-011

For existing kits in stock

- remove paperwork
- remove all D2771-BCFC-025-175 bolts (QTY 8 from -011 and -021) (QTY 12 from -012 and -022)
- remove D2771-LCC-025 nuts (QTY 16 from -011 and -021) (QTY 24 from -012 and -022)
- remove 8 of 16 D2529 washers (ensure QTY 8 remain in kit) for -011 and -021
- remove 12 of 24 D2529 washers (ensure QTY 12 remain in kit) for -013 and -023
- ensure no D2022-101 spacers are in kit
- add AN4-15A bolts (QTY 8 for -011 and -021) (QTY 12 for -012 and -022)
- add AN960JD416 washers (QTY 8 for -011 and -021) (QTY 12 for -012 and -022)
- add MS21042-4 (or MS21042L4) nuts (QTY 8 for -011 and -021) (QTY 12 for -012 and -022)
- add new paperwork with DSI 9140, drawing D500-572 rev C

Change Numbers (QSI 014)

- "change 3" should be indicated on paws that are in stock and have new hardware added. They can be identified by having a counterbore on the top surface of each clamp hole.
- "change 4" should be indicated for new production of bearpaws, which will not have a counterbore on the top surface of each clamp hole.

For production

- change HAAS programs for bearpaws to remove top counterbore
- update IPPs and BOMs to reflect new hardware

D206-559

For existing kits in stock

- remove paperwork
- remove all D2771-BCFC-025-175 bolts (QTY 8 from -011, -021) (QTY 12 from -013, -015, -023, -025)
- remove D2771-LCC-025 nuts (QTY 16 from -011, -021) (QTY 24 from -013, -015, -023, -025)
- remove 8 of 16 D2529 washers (ensure QTY 8 remain in kit) for -011 and -021
- remove 12 of 24 D2529 washers (ensure QTY 12 remain in kit) for -013, -015, -023, -025
- ensure no D2022-101 spacers are in kit
- add AN4-15A bolts (QTY 8 for -011, -021) (QTY 12 for -013, -015, -023, -025)
- add AN4-17A bolts (QTY 8 for -011, -021) (QTY 12 for -013, -015, -023, -025)
- add AN960JD416 washers (QTY 16 for -011, -021) (QTY 24 for -013, -015, -023, -025)
- add MS21042-4 (or MS21042L4) nuts (QTY 8 for -011, -021) (QTY 12 for -013, -015, -023, -025)
- add new paperwork with DSI 9142, drawing D206-559 rev G

Change Numbers (QSI 014)

- "change 3" should be indicated on paws that are in stock and have new hardware added. They can be identified by having a counterbore on the top surface of each clamp hole.
- "change 4" should be indicated for new production of bearpaws, which will not have a counterbore on the top surface of each clamp hole.

For production

- change HAAS programs for bearpaws to remove top counterbore
- update IPPs and BOMs to reflect new hardware

D205-564

For existing kits in stock

- remove paperwork
- remove all D2771-BCFC-025-150 bolts (QTY 16)
- remove D2771-LCC-025 nuts (QTY 32)
- remove 16 of 32 D2529 washers (ensure QTY 16 remain in kit)
- add AN4-13A bolts (QTY 16)
- add AN960JD416 washers (QTY 16)
- add MS21042-4 (or MS21042L4) nuts (QTY 16)
- add new paperwork with drawing D205-564 rev B

Change Numbers (QSI 014)

- "change 3" should be indicated on paws that are in stock and have new hardware added. They can be identified by having a counterbore on the top surface of each clamp hole.
- "change 4" should be indicated for new production of bearpaws, which will not have a counterbore on the top surface of each clamp hole.

For production

- change HAAS programs for bearpaws to remove top counterbore
- update IPPs and BOMs to reflect new hardware